

SHIP 08/05

Dart Aerospace Ltd.

Date: Thursday, 4/12/2007 8:51:58 AM
User: Kim Johnston

Process Sheet

PK

SPLIT

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 31744

Estimate Number : 12760

P.O. Number :

This Issue : 4/12/2007 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : SMALL / MED FAB

Previous Run : 31568

Drawing Name : STEP ACTUATOR ASSEMBLY

Part Number : 41232 000 001 002

Drawing Number : 41232-000-001 REV A

Project Number : N/A

Drawing Revision : A

Material :

Due Date : 5/10/2007 Qty: 4 Um: Each

Written By : 07.04.12Checked & Approved By : 07.04.12

Comment : Est Rev: A New Issue 07-02-28 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP41232-000-001 CHG 001

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

AP0925ELBN

BARBED ELBOW



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

BARBED ELBOW

Batch: M103727 ✓ ✓

Washer

4.0

AN960JD416



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: M102929 ✓ ✓

Nut

5.0

MS21042L4



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M103914 ✓ ✓

7/5/4 SP

Date: Thursday, 4/12/2007 8:51:58 AM
Jser: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH STEP ACTUATOR ASSEMBLY

Job Number: 31744

Part Number: 41232 000 001 002

Job Number:



Seq. #: Machine Or Operation: Description:

6.0 AN423A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch:

M103688

M14067

7.0 MS3548993 GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

GROMMET

Batch:

M103688

8.0 AN960JD416L Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

9.0 MS24665151 Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Cotter Pin

10.0 MS203923C21 Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pin

11.0 R 3400



Comment: Qty.: 3.0500 f(s)/Unit Total: 12.2000 f(s)

plastic tubing 1/4id x 3/8od-black

Cut to 18" Long X2

Batch:

M103351

M104229

12.0 41232 200 006 001



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket

Batch:

B30505

7/8/3 59

Date: Thursday, 4/12/2007 8:51:58 AM
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Process Sheet

RM

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH STEP ACTUATOR ASSEMBLY

Job Number: 31744

Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

41232 200 005 001

Spacer (Step Actuator)



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Spacer (Step Actuator)

Batch:

B30503 ✓

14.0

41232 200 004 001

Reducer Tee Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Reducer Tee Assembly

Batch:

B30502 ✓

B31018 ✓

31779 ✓

15.0

41232 200 003 001

Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spring (Step Actuator)

Batch:

N/A ✓

16.0

41232 200 001 002

Step Actuator RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Step Actuator RH

Batch:

B31745 ✓

1X - B31746

B3

17.0

41232 200 003 001

Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spring (Step Actuator)

BATCH:

B30501 ✓

B30940 ✓

7/5/13 SQ

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C207105116

7/5/13

(1) C207105115

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP 41232-000-001-001

Location:

PPP Rev:

Rev Draft

7/5/15 SQ

(1)

add to kit 1 base 124K002 4CR 0545 ✓ m104384 ✓

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Drawing Name: LH STEP ACTUATOR ASSEMBLY

Job Number: 31744

Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

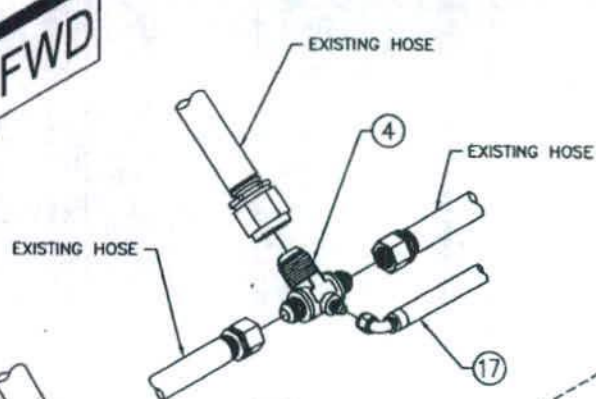
Comment: FINAL INSPECTION/W/O RELEASE

107/05/18

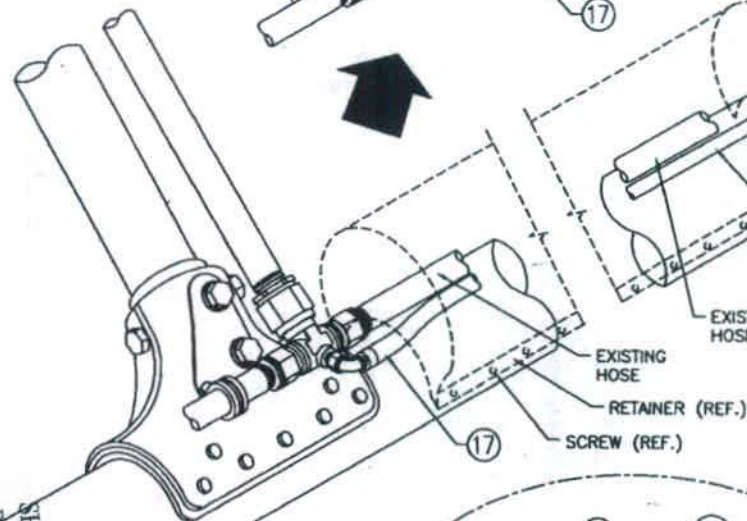
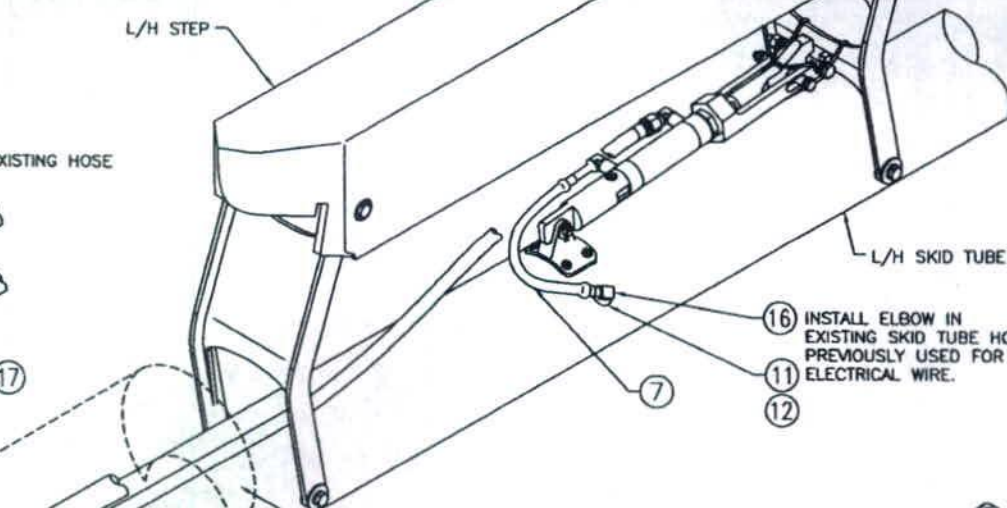
Job Completion



U A. 05.18



L/H STEP

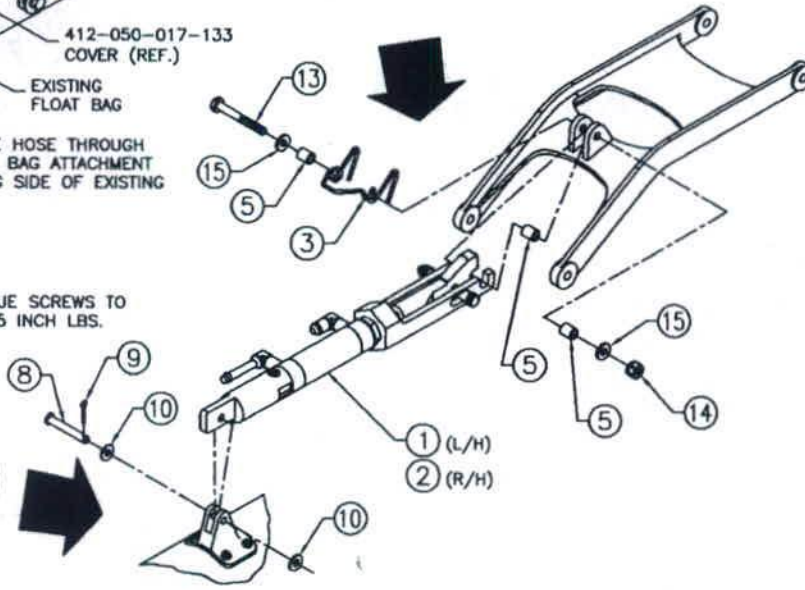
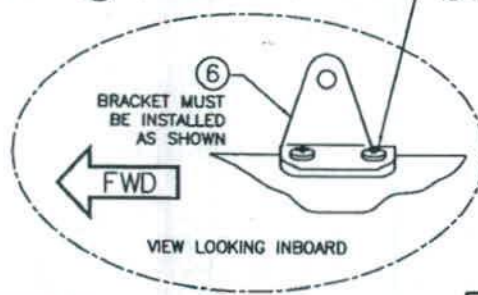


412-050-017-133 COVER (REF.)

EXISTING FLOAT BAG

ROUTE HOSE THROUGH FLOAT BAG ATTACHMENT ALONG SIDE OF EXISTING HOSE.

TORQUE SCREWS TO 12-15 INCH LBS.



-001 L/H INSTALLATION (SHOWN)
-002 R/H INSTALLATION (OPPOSITE)

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STEP ACTUATOR INSTALLATION

REV. NO.	41232-000-001	REV.	A
SHT	2 OF 2		

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51744

